

Date: Thursday, 14/05/2009 3:41:28 PM
 *User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 47970		
Estimate Number	: 11744		
P.O. Number	:	Part Number	: D3394041
This Issue	: 14/05/2009 S.O. No. :	Drawing Number	: D3394 R4EV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 46861	Material	:
Written By	:	Due Date	: 21/05/2009 Qty: 80 Um: Each
Checked & Approved By	: <u>JLD 09.05.14</u>		
Comment	: Est Rev: A New Issue 06-01-06 JLM Est Rev: B Now Manufactured in House 09-04-07 JLM Verified BY: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0735 f(s)/Unit Total : 5.8800 f(s) 45800 x 40 2.94
 D2423 Lug Extrusion 28 = 2.058 0.882
 Batch: B43721 x 20 B44529 x 12 26 scrap. mmf 09/05/25



2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut Blank to .850"

mmf 09/05/25



3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA808 Rev: AA & Dwg D3394 Rev: A

2-Deburr per dwg D3394

mmf 09/05/29 JP 09/05/30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/05/29



5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK



SL 09/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 47970

Part Number: D3394041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

MD 09/06/02

180

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:45
OVEN TEMPERATURE: 320°
FINISH TIME: 12:15

FL 09/06/02

80

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09/06/02

80

9.0 MS3548993 GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS35489-93 Grommet

M110985 81x

M111477 1094

09/06/03

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3394

09/06/03 80

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/03 counter 80

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 474

26/4

80x

Sip

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Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/05 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF-
09-08-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

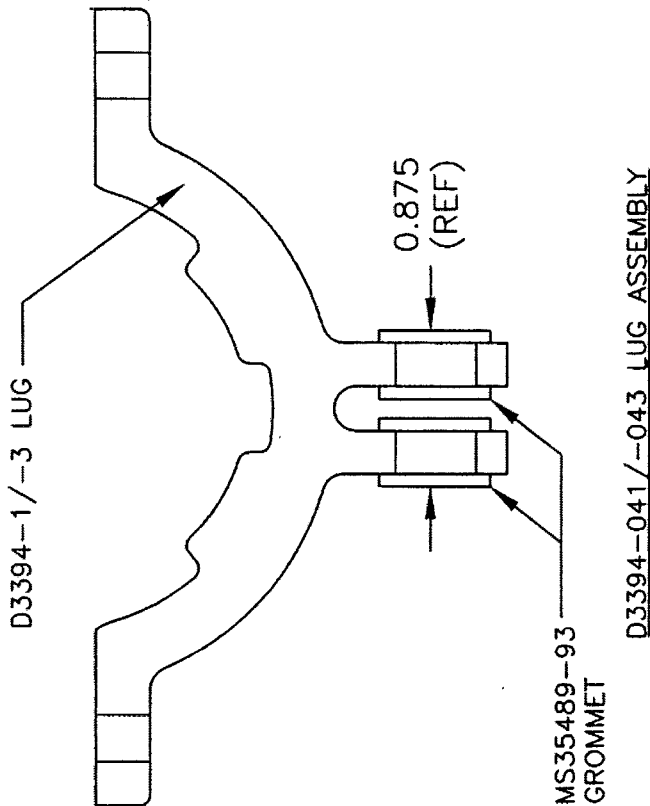
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

QTY -		PART NUMBER	DESCRIPTION
041	X	D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
		D3394-1	LUG
	1	D3394-3	LUG
	2	MS35489-93	GROMMET

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WORK ORDER

NO
RELEASED
05.11.14

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

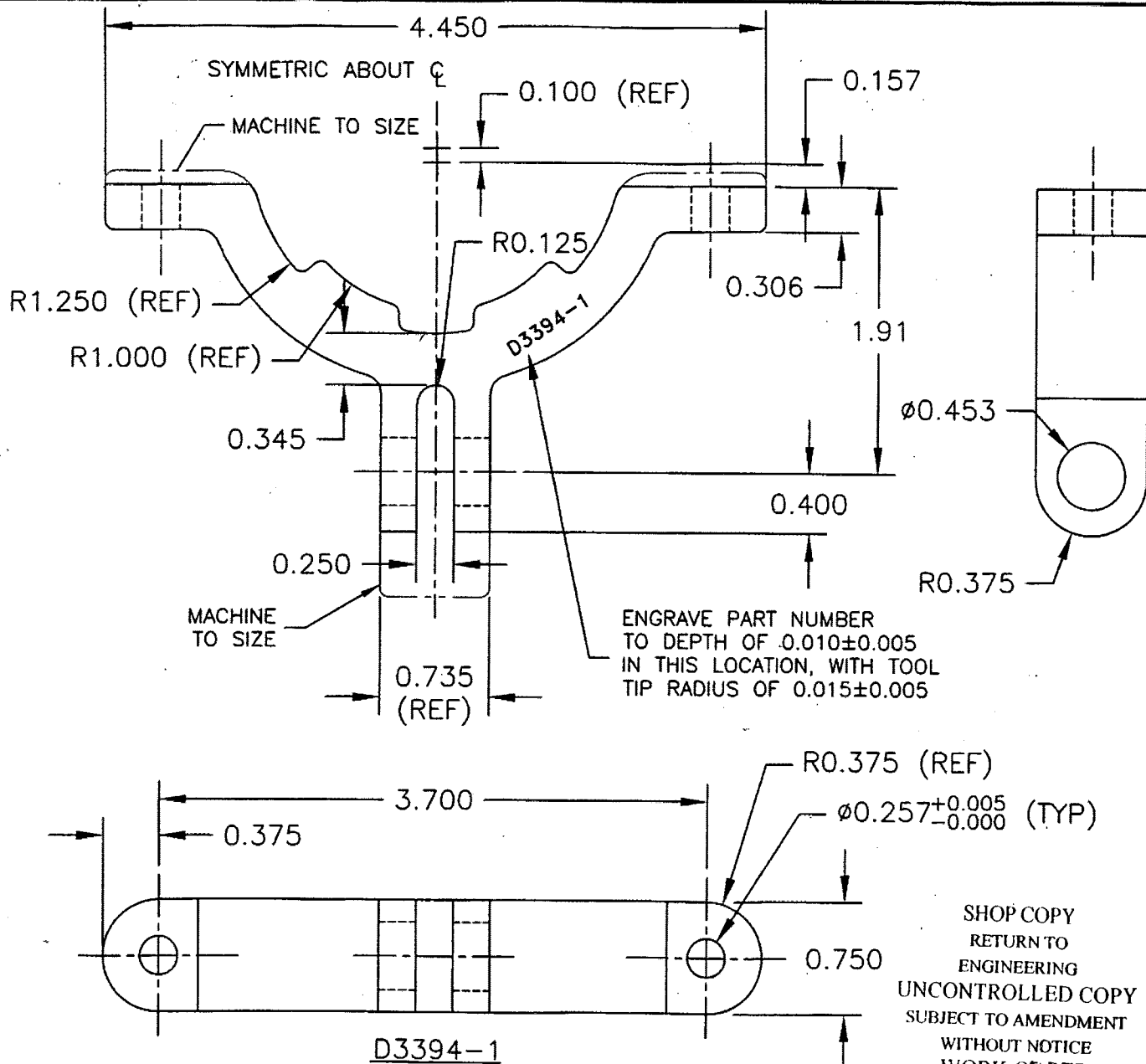
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14	TITLE LUG	SCALE 1:1	

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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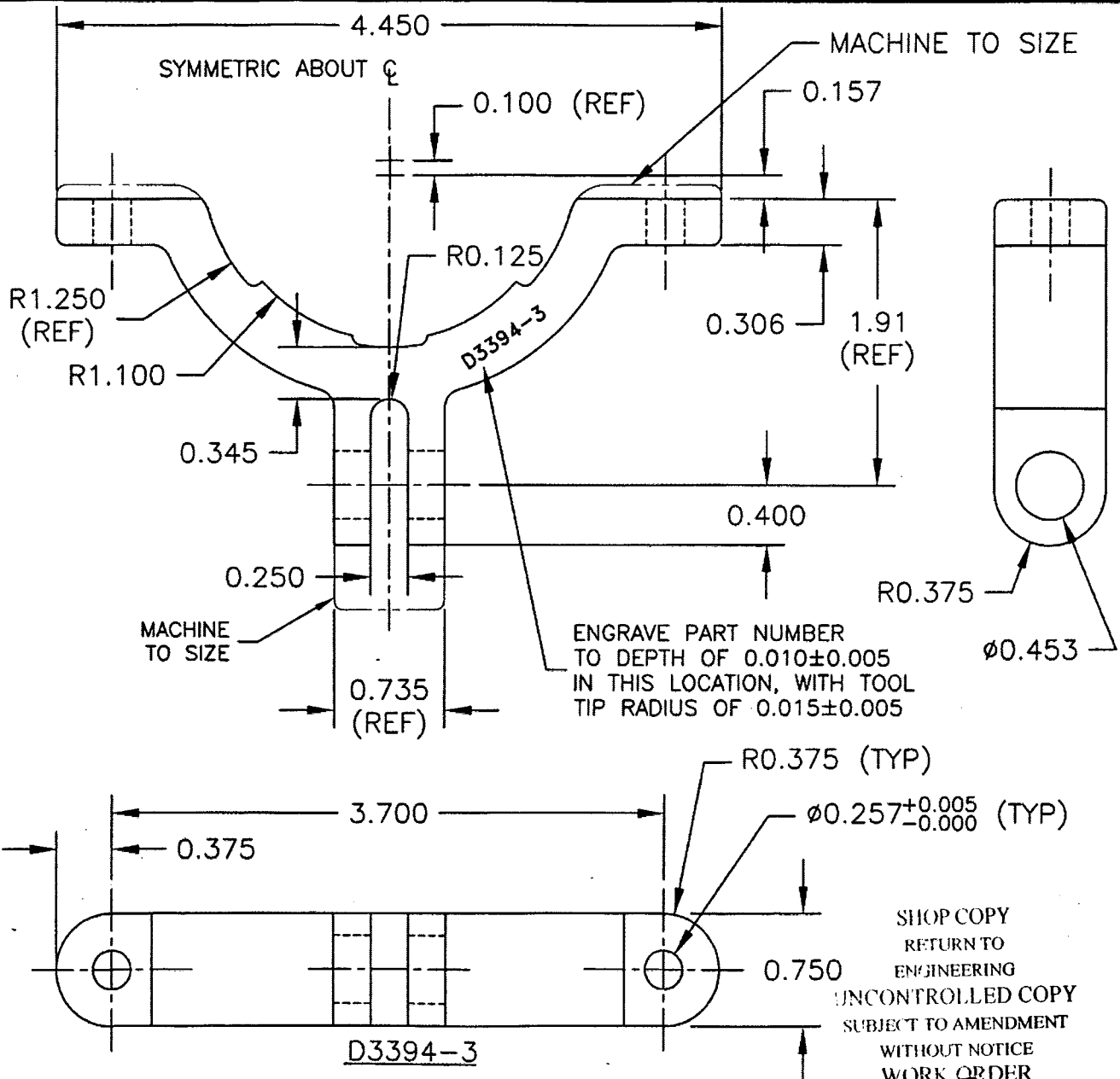
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DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3394
DATE	05.02.14	TITLE	LUG	REV. A SHEET 3 OF 3 SCALE 1:1

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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